

1 **WHAT IS CLAIMED IS:**

1 1. A method for forming a component for a vehicle comprising:
2 forming a substrate in a mold by injecting a first resin into a first cavity,
3 reconfiguring a portion of the mold to form a second cavity, and injecting a second resin
4 into a second cavity;
5 providing a flexible member adjacent at least a portion of the substrate to
6 form a cavity between the substrate and the flexible member;
7 coupling at least a portion of the flexible member to the substrate; and
8 introducing a material into the cavity after securing at least a portion of the
9 flexible member to the substrate;
10 wherein the flexible member and the material introduced into the cavity form
11 a cushioned region for the vehicle component.

1 2. The method of Claim 1 wherein the flexible member is provided in a region
2 of the interior panel intended to be contacted by an occupant of the vehicle.

1 3. The method of Claim 1 further comprising forming the flexible member
2 utilizing at least one of a slush molding process, a vacuum forming process, an injection
3 molding process, an extrusion process, and a casting process.

1 4. The method of Claim 1 wherein the flexible member is formed of a material
2 selected from the group consisting of textiles, polyurethane, polyvinylchloride, a
3 thermoplastic olefin, and combinations thereof.

1 5. The method of Claim 1 wherein the step of introducing the material into the
2 cavity comprises introducing the material into the cavity and expanding the material.

1 6. The method of Claim 5 wherein the material is introduced into the cavity
2 through an aperture formed in the substrate.

1 7. The method of Claim 6 wherein the material introduced into the cavity is a
2 foam material.

1 8. The method of Claim 1 wherein the flexible member includes a first feature
2 configured for coupling with a second feature provided on the substrate, and wherein the

3 step of coupling the skin to the substrate comprises coupling the first feature to the second
4 feature.

1 9. The method of Claim 8 wherein the step of coupling the flexible member to
2 the substrate comprises securing the flexible member to the substrate with a vacuum.

1 10. The method of Claim 9 wherein the substrate includes at least one aperture
2 so that air within the cavity is drawn through the aperture by the vacuum device.

1 11. The method of Claim 10 wherein the aperture is provided in the substrate at
2 the location where the first feature is coupled to the second feature.

1 12. The method of Claim 10 wherein the aperture is provided in the substrate at a
2 location intermediate the location of a boundary formed between the flexible member and
3 the substrate and the location where the first feature is coupled to the second feature.

1 13. The method of Claim 10 wherein the location where the first feature is
2 coupled to the second feature is provided intermediate the location of a boundary formed
3 between the flexible member and the substrate and the location of the aperture.

1 14. The method of Claim 1 wherein the step of forming a substrate comprises:
2 providing a first mold section, a second mold section, and a shut-off member
3 movable between a first position and a second position;
4 providing a first cavity defined by the first mold section, the second mold
5 section, and the shut-off member when in the first position; and
6 providing a second cavity is defined by the first mold section, the second
7 mold section, the first resin, and the shut off member when in the second position.

1 15. The method of Claim 1 wherein the first resin comprises a first polymeric
2 material and the second resin comprises a second polymeric material different than the first
3 polymeric material.

1 16. The method of Claim 15 wherein the first resin comprises a first color and
2 the second resin comprises a second color different than the first color.

1 17. The method of Claim 1 wherein the first resin comprises a first polymeric
2 material and the second resin comprises a second polymeric material which is the same as
3 the first polymeric material.

1 18. The method of Claim 17 wherein the first polymeric material comprises a
2 first color and the second polymeric material comprises a second color different than the
3 first color.

1 19. The method of Claim 1 wherein the first resin comprises a first color and the
2 second resin comprises a second color different than the first color.

1 20. The method Claim 1 wherein the component comprises an interior trim panel
2 for a vehicle.

1 21. A trim panel for use in a vehicle, the trim panel comprising:
2 a one-piece molded member having a first substrate portion made of a first
3 resin, a second substrate portion made of a second resin, and a cushioned layer at least
4 partially covering one of the first substrate portion and the second substrate portion,
5 wherein the one-piece molded member is formed by a process wherein the
6 cushioned layer is positioned into at least one of a first cavity and a second cavity, the first
7 resin is injected into the first cavity, a retractor member is moved to define a second cavity,
8 and the second resin is injected into the second cavity.